

BLUE

Dart Aerospace Ltd.

23

Wednesday, 5/16/2007 8:13:41 AM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32380
Estimate Number : 10834
P.O. Number : N/A
This Issue : 5/16/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 31251
Written By :
Checked & Approved By :
Comment : Est: B 06.06.26 New DWG rev (mpp 2069) EC
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Part Number : D29332
Drawing Number : D2933 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 6/6/2007 Qty: 16 Unit: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

10

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: B25345

J.L 07/05/27

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

J.F. / J.L 07/05/28

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Er 07/06/07

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. / Er 07/06/07

Date: Wednesday, 5/16/2007 8:13:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 32380

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation: Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

smk 07/06/09 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W 07-06 (12) 16

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

*Atelier
Debrossage
PO 4034 U 07-06-25 (1)*

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

June 22

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/25 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/25

Job Completion



U 07-06-25

DART AEROSPACE LTD	Work Order: 32380
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.119	.119	.119	.119		
B	0.100	0.140		.119	.120	.120	.119		
C	0.100	0.140		.124	.120	.120	.119		
D	0.210	0.230		.222	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.549	.550	.550	.550		
P	0.490	0.510		.501	.500	.500	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.252	.251	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.137	1.137	1.136	1.137		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.576	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JL	Audited by: [Signature]
Date: 07/05/07	Date: 07/06/07

Audited by: [Signature]
Date: 07/06/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.122	.121	.120		
B	0.100	0.140		.120	.120	.120	.119		
C	0.100	0.140		.121	.119	.120	.120		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.518	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.119	.119	.119	.120		
O	0.540	0.560		.549	.549	.550	.550		
P	0.490	0.510		.501	.499	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.251	.251	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.629	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.136	1.135	1.137	1.140		
Y	1.565	1.585	DT8695-A/B	1.575	1.575	1.576	1.578		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	07/05/28 / 07/06/07

Audited by:	JK
Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32380
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.120	.120"		
B	0.100	0.140		.120	.120	.120	.116"		
C	0.100	0.140		.121	.121	.119	.125"		
D	0.210	0.230		.221	.220	.219	.224"		
E	1.245	1.255		1.256	1.256	1.250	1.250"		
F	1.245	1.255		1.250	1.250	1.250	1.250"		
G	2.495	2.505		2.500	2.500	2.500	2.500"		
H	0.510	0.515		0.511	0.511	0.511	0.511"		
I	1.572	1.582		1.577	1.577	1.577	1.577"		
J	2.495	2.505		2.500	2.500	2.500	2.500"		
K	0.257	0.262		.259	.259	.259	.259"		
L	0.312	0.317		.315	.315	.315	.315"		
M	0.235	0.240		0.239	0.239	0.239	0.239"		
N	0.100	0.140		.120	.120	.119	.119"		
O	0.540	0.560		.548	.550	.550	.550"		
P	0.490	0.510		.501	.502	.502	.507"		
Q	3.715	3.725		3.720	3.720	3.717	3.720"		
R	2.470	2.510		2.490	2.490	2.490	2.490"		
S	0.240	0.270		.252	.250	.252	.256"		
T	0.100	0.180		.140	.140	.140	.140"		
U	1.625	1.635		1.630	1.630	1.630	1.630"		
V	1.362	1.372		1.367	1.367	1.367	1.367"		
W	0.316	0.321		.320	.320	.320	.320"		
X	1.125	1.145		1.135	1.135	1.135	1.135"		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575"		
Z	0.178	0.198		.188	.188	.188	.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / J.F. / E	Audited by: MK
Date: 07/05/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	3238C
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.117"	.120"	.121"	.119"		
B	0.100	0.140		.117"	.122"	.122"	.121"		
C	0.100	0.140		.125"	.125"	.125"	.125"		
D	0.210	0.230		.224"	.225"	.223"	.225"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		0.519"	0.519"	0.519"	0.519"		
I	1.572	1.582		1.579"	1.579"	1.579"	1.579"		
J	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
K	0.257	0.262		0.259"	0.259"	0.259"	0.259"		
L	0.312	0.317		0.313"	0.313"	0.313"	0.313"		
M	0.235	0.240		0.239"	0.239"	0.239"	0.239"		
N	0.100	0.140		.120"	.118"	.119"	.121"		
O	0.540	0.560		.552"	.550"	.547"	.550"		
P	0.490	0.510		.504"	.505"	.504"	.505"		
Q	3.715	3.725		3.720"	3.720"	3.720"	3.720"		
R	2.470	2.510		2.490"	2.490"	2.490"	2.490"		
S	0.240	0.270		.256"	.256"	.256"	.255"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.370"	1.370"	1.370"	1.370"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.125	1.145		1.135"	1.136"	1.132"	1.138"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		A.188"	A.188"	A.188"	A.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.	Audited by: J.F.
Date: 07/05/29 / 07/06/09	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

SECTION B-B

PCOPY
TURN TO
INFORMING

2.490
±0.020

CHA 3.720
THIS

0.51

83.6

06.11

00.05

39.10

ANN B

PROV

R0.250 (TYP)

R0.525 (TYP)

CHAMFER 0.050 x 45°
(ALL AROUND)

±0.005 1.250±0.005

0.000

C-C

(WN)
(SITE)

R0.188 (C)
(AROUND POCKET)

R0.50 (TYP)

R1.575

0.140 (B)

0.100

1.000

0.500

0.115

0.240 (R)

0.235

R0.025

1.605±0.005

48.0°

5 4.1
DART QSI 005 4.3

NOTED.

TO 0.015 DEEP

0.510±0.005